

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: **2017-118** Date Opened: **18 July 2017** Title: **Fabrication**Aircraft OEM: **Multiple** Aircraft Model: **Multiple** Product Type: **Cargo Basket** Product Model: **Handle (Ski)** Quantity: **7****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

DH
N/A
DH
N/A
N/A
JC
N/A
N/A

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

7
N/A
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JC
JC

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

N/A
JC
N/A
N/A
N/A

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
36277	1	Handle Bar	DH
36274	3	Bushing	DH
36275	4	Bushing and Support	DH
84261	2	Handle Assembly	DH
84265	2	Lever	DH

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC
N/A
N/A

**Traveller**

Initial or N/A


Work performed by:

ICC / Dual Inspection performed by:

Work Order closed by:

Form 20.D.03

Print: D. MartynPrint: J. ClarkePrint: J. Clarke

Rev. Original 23 Sep 2014

Sign: Sign: Sign: SCA: AD05SCA: AD02SCA: AD02Date: 19-Jul-17Date: 19-Jul-17Date: 19-Jul-17



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

**Serviceable**

**Remarks**

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AMF 73-04

Nomenclature: Handle lever assy. No. of pieces: 19

Manufacturer: Aero Design Ltd.

Part No.: ~~36277-01~~ DRM Serial No.: NA

TSN: 84261-02 TSO: NA Rem.: NA

Work Order No.: 2017-65

Remaining Tasks to be Performed: weld to tube

Signature: David Murty

Date: April 12/2017 Lic. No. / SCA AD-05



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AMF 73-04

**Remarks**

**Serviceable**

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AMF 73-04

Nomenclature: Handle lever assy. No. of pieces: 19

Manufacturer: Aero Design Ltd.

Part No.: 84261-02 Serial No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-65

Remaining Tasks to be Performed: weld to tube

Signature: David Thorne

Date: April 12/2017 Lic. No. / SCA AD-05



## CARGO BASKET HANDLE ASSEMBLY

### General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2017-118

Date Open: July 18, 2017

Complete  
(initial or SCA #)

AD  
73-04  
02 *DA*

1. Fabricate Handle Assembly

- Temporarily install handle levers on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
- Measure across TOP side of levers.
- Cut handle tubing to length measured.
  - Handles under 40" long: 1.0" x 0.035 round tube
  - Handles over 40" long: 1.0" x 0.065 round tube
- De-burr tube.
- Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
- Record material PO on attached material list.

2. Weld Handle Assembly

- Fuse tube to lever on both ends. Ensure levers are parallel.

3. Clean up

- Clean welded area with scotch-brite.

4. Final Inspection

- Welds for complete and handle for fit.
- Tag complete and inspected parts in preparation for installation.

AD  
73-04  
05

AD  
73-04  
02 *DA*

AD  
73-04  
02 *AD*  
*73-04*  
*05*

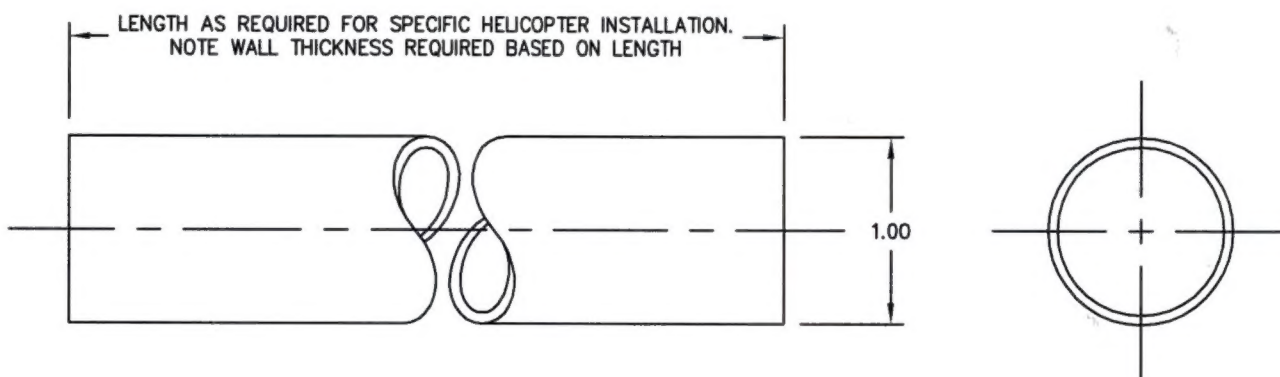
Work Order: 2017-118Date Opened: July 18, 2017Material Tracking Sheet  
Eurocopter AS350 / AS355  
Extra Large Basket Handle Assembly

1 of 1

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>7</u>	84261	<b>84261-01</b>	<b>Handle Assembly</b>		
<b>Step 1</b>				<i>Weld Lever Assembly</i>		<u>2017-65</u>
	. 2		84265-01	Lever	304 Stainless, 0.105 Sheet	
	. 2		36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	
	. 2		MS20615-4M3	Rivet		
	. A/R			Welding Rod	ER308L TIG Rod	
<b>Step 2</b>				<i>Clean Up</i>	<i>None</i>	
<b>Step 3</b>				<i>Fabricate Handle Bar</i>		
	. 1		36277-01	Handle Bar	316 Stainless, 1.0 x 0.065 Rnd. Tube	<u>17005</u>
<b>Step 4</b>				<i>Weld Handle Assembly</i>	<i>None - Fuse weld, no rod req.</i>	
<b>Step 5</b>				<i>Clean Up</i>	<i>None</i>	
<b>Step 6</b>				<i>Inspection - Final Assembly</i>	<i>None</i>	

600# 2017-118

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36210	STF	MAY 17/02
1	UPDATE TITLE BLOCK, ADD ALTERNATE MATERIALS	BJC	MAR 13/14




01 HANDLE BAR

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.

	01	(ALTERNATE MATERIAL)	316 STAINLESS STEEL	ASTM A213	1.0" X 0.065" TUBE
	01	HANDLE BAR (OVER 40")	304 STAINLESS STEEL	ASTM A213	1.0" X 0.065" TUBE
	01	(ALTERNATE MATERIAL)	316 STAINLESS STEEL	ASTM A213	1.0" X 0.035" TUBE
36277-01	01	HANDLE BAR (UP TO 40")	304 STAINLESS STEEL	ASTM A213	1.0" X 0.035" TUBE
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

QTY	LIST OF MATERIALS
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<p>THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE REPERENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.</p>	<p>APPROVALS</p> <p>DRAWN: STEVEN FAHEY</p> <p>CHECKED: E. BURGOIN</p>	<p>DATE</p> <p>MAY 17/02</p> <p>MAY 01/03</p>	 <p><b>AERO DESIGN LTD.</b></p> <p>9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 <a href="http://www.aerodesign.ca">www.aerodesign.ca</a></p>	<p><b>HELICOPTER CARGO BASKET HANDLE BAR</b></p>											
	<p>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:</p> <table><tr><td>DECIMALS</td><td>ANGLES</td></tr><tr><td>X.XXX ±0.010</td><td>±1/2°</td></tr><tr><td>X.XX ±0.03</td><td></td></tr><tr><td>X.X ±0.1</td><td></td></tr></table>						DECIMALS	ANGLES	X.XXX ±0.010	±1/2°	X.XX ±0.03		X.X ±0.1		
	DECIMALS	ANGLES													
	X.XXX ±0.010	±1/2°													
	X.XX ±0.03														
X.X ±0.1															
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.												
SHEET 1 OF 1	A4	36277	1												

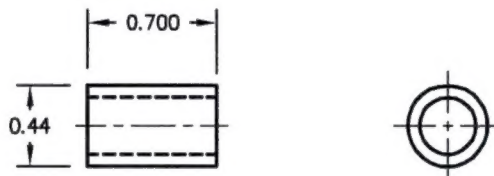


WG# 2017-118

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36210	STF	MAY 17/02
1	REMOVE ALTERNATE PART, REMOVE STEP FROM BUSHING	BJC	JAN 8/07
2	LENGTH CHANGED	BJC	NOV 03/09
3	TITLE BLOCK UPDATE, ADD ALTERNATE MATERIAL	BJC	MAR 13/14

NOTES:


1. REMOVE ALL BURRS AND SHARP EDGES.



01 BUSHING

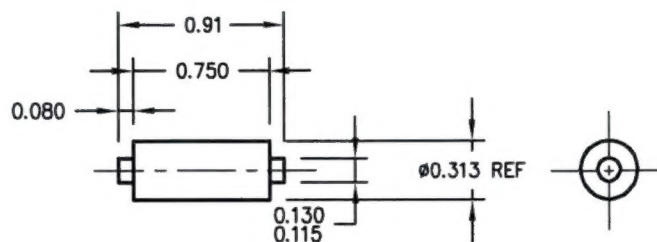
	01	(ALTERNATE MATERIAL)	316 STAINLESS STEEL	ASTM A269	7/16" X 0.065" TUBE
36274-01	01	BUSHING	304 STAINLESS STEEL	ASTM A269	7/16" X 0.065" TUBE
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

QTY LIST OF MATERIALS

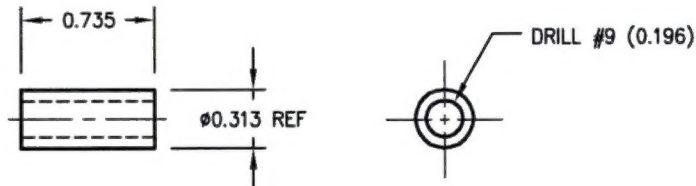
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	DRAWN: STEVEN FAHEY	MAY 17/02				
	CHECKED: E. BURGOIN	MAY 01/03				
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		HELICOPTER CARGO BASKET HANDLE LEVER BUSHING			
	DECIMALS	ANGLES	SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
X.XXX ±0.010	±1/2°	SHEET 1 OF 1	A4	36274	3	
X.XX ±0.03						
X.X ±0.1						

311-2617-118

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36210	STF	MAY 17/02
1	ADDED PART 02. BUSHING WAS STAINLESS STEEL	STF	JUN 03/04
2	DIMENSIONS UPDATED	BJC	JAN 8/07
3	LENGTHS CHANGED	BJC	NOV 03/09
4	TITLE BLOCK UPDATED, MATERIALS CHANGED	BJC	04/10/2013



02 SUPPORT




01 BUSHING

NOTES:

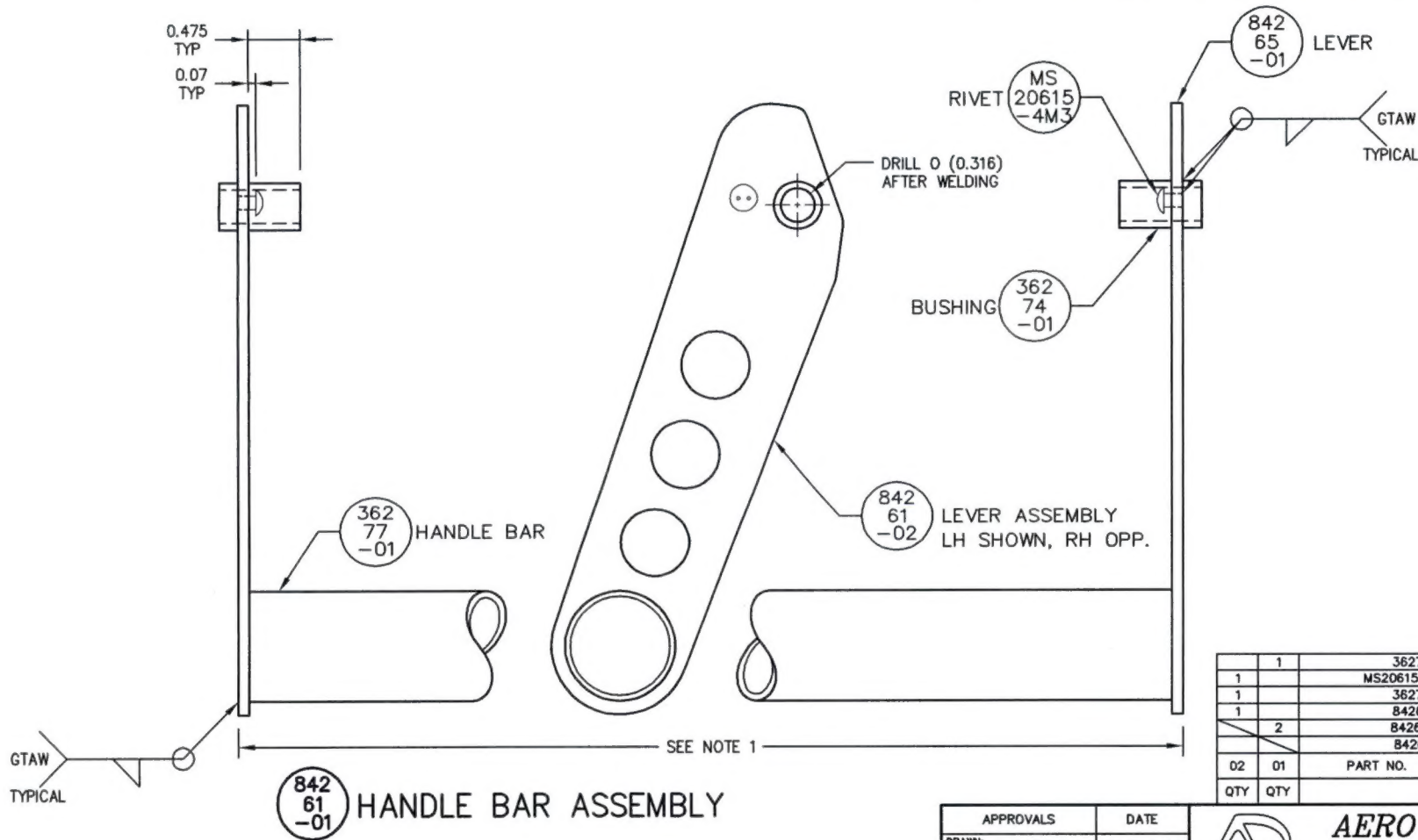
1. REMOVE ALL BURRS AND SHARP EDGES.

	36275-02	01	SUPPORT	304 STAINLESS STEEL	ASTM A479	5/16" ROD
	36275-01	01	BUSHING	360 BRASS	ASTM B16	5/16" ROD
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

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	DRAWN: STEVEN FAHEY		MAY 17/02			9888A MALASPINA ROAD			
	CHECKED: E. BURGAIN		MAY 01/03			POWELL RIVER, BC, CANADA, V8A 0G3			
					TEL: 804.483.2376				
					www.aerodesign.ca				
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				HELICOPTER CARGO BASKET HANDLE BUSHING AND SUPPORT			
		DECIMALS		ANGLES					
		X.XXX ±0.010		±1/2"					
		X.XX ±0.03							
		X.X ±0.1							
		SCALE 1 : 1		DWG. SIZE		DWG. NO.		REV.	
		SHEET 1 OF 1		A4		36275		4	

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

QTY	QTY	DESCRIPTION
1	1	36277-01 HANDLE BAR
1	1	MS20615-4M3 RIVET (MONEL)
1	1	36274-01 BUSHING
1	1	84265-01 LEVER
2	2	84261-02 LEVER ASSEMBLY (RH/LH)
2	2	84261-01 HANDLE BAR ASSY
QTY	QTY	DESCRIPTION

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1



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**HELICOPTER CARGO BASKET  
HANDLE BAR ASSEMBLY**

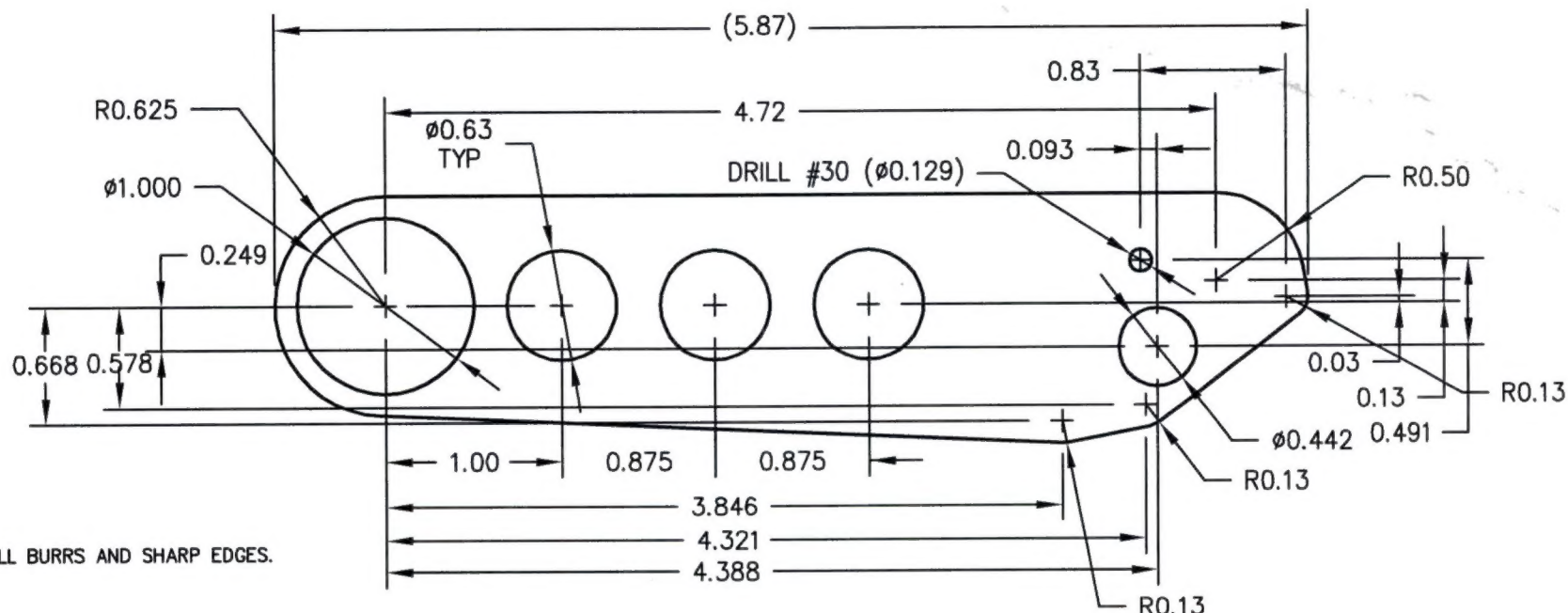
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84261	2

311-LPC PM



wd 2d7-118

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	REMOVE TOOLING HOLES, ADD LIGHTENING HOLES	BJC	18/06/2010
2	TITLE BLOCK UPDATED, ADD ALTERNATE MATERIAL	BJC	13/03/2014




NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.

01 LEVER

	01	(ALTERNATE MATERIAL)	AISI 304 STAINLESS	AMS 5513	0.125" SHEET
84265-01	01	LEVER	AISI 304 STAINLESS	AMS 5513	0.100" SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

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	DRAWN: R. RATHWELL	JUNE 18/09					
	CHECKED: E. BURGOIN		<p><b>HELICOPTER CARGO BASKET HANDLE LEVER</b></p>				
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1						
SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.			
SHEET 1 OF 1		A4	84265	2			